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IS 14466 : 1997
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(Superseding IS 4125 : 1987)

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भारतीय मानक

वस्त्र — दोषों का विवरण — शब्दावली

Indian Standard

FABRICS — DESCRIPTION OF DEFECTS — VOCABULARY

ICS 59.080.30; 01.040.59

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BUREAU OF INDIAN STANDARDS
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI 110002

July 1997 **Price Group 6**

Cotton and Cotton Products Sectional Committee, TX 02

NATIONAL FOREWORD

This Indian Standard which is identical with ISO 8498 : 1990 'Woven fabrics — Description of defects — Vocabulary' issued by the International Organization for Standardization (ISO) was adopted by the Bureau of Indian Standards on the recommendation of the Cotton and Cotton Products Sectional Committee and approval of the Textile Division Council.

The text of ISO Standard has been approved as suitable for publication as Indian Standard without deviations. Certain conventions are, however, not identical to those used in Indian Standards. Attention is particularly drawn to the following:

a) Wherever the words 'International Standard' appear referring to this standard, they should be read as 'Indian Standard'.

b) Comma (,) has been used as a decimal marker in the International Standard, while in Indian Standards the current practice is to use a point (.) as the decimal marker.

Only English language text in the International Standard has been retained while adopting it as Indian Standard.

AMENDMENT NO. 1 JULY 1999
TO
IS 14466 : 1997/ISO 8498:1990 FABRICS — DESCRIPTION OF DEFECTS — VOCABULARY

(*First cover page, Hindi Title*) — Substitute the existing with the following:

बुने हुए कपड़े—दोषों का विवरण—शब्दावली

(*First cover page and page* 1, *English Title*) — Substitute the existing with the following:

'WOVEN FABRICS — DESCRIPTION OF DEFECTS — VOCABULARY'

(*Second cover page, NATIONAL FOREWORD*)— Insert the following at the end:

"At the time of revision of IS 4125 : 1987 'Glossary of terms pertaining to defects in fabrics', in order to align the Indian Standard with corresponding International Standard, it was decided to adopt ISO 8498 : 1990 'Woven Fabrics — Description of Defects — Vocabulary' and ISO 8499 : 1990 'Knitted Fabrics — Description of Defects — Vocabulary' under dual numbering system. IS 14717 : 1999 covers description of defects in knitted fabrics. Accordingly, this standard supersedes IS 4125 : 1987."

(TX 02)

Reprography Unit, BIS, New Delhi, India

Indian Standard

FABRICS — DESCRIPTION OF DEFECTS — VOCABULARY

Section 1: General

1.1 Scope

This International Standard describes defects which commonly appear during the inspection of woven piece-goods.

The purpose of this International Standard is to define woven-fabric defects, i.e. those characteristics that have been unintentionally introduced into the fabric. The presence of one or other of these characteristics in a fabric does not automatically imply that the fabric is sub-standard. Textile suppliers and purchasers will still have to reach agreement on whether a defect is present. If it is considered that a defect is present, they will then have to agree on the limits of the defect and on any allowance to be made, bearing in mind the intended use of the fabric.

Sections 2 to 7 of this International Standard cover the following groups of defects:

Section 2: Yarn defects in a woven fabric

Section 3: Defects in the weft direction

Section 4: Defects in the warp direction

Section 5: Defects due to, or apparent after, dyeing, printing or finishing

Section 6: Defects of, or associated with, the selvedges

Section 7: General defects

1.2 General definitions

For the purposes of this International Standard, the following general definitions apply:

1.2.1 band: A weft-way region of the fabric that extends across the full width and is different from the rest of the fabric. It may or may not run parallel with the picks, and may or may not have clearly defined edges.

1.2.2 defect: A fault that would reduce the expected performance of the fabric or, if it appeared in a prominent position in an article made from the fabric, would readily be seen and rejected by a prospective purchaser.

1.2.3 line: A narrow variation, often only one thread wide, in the warp direction.

1.2.4 streak: A variation of generally varying width which may or may not be parallel to the warp direction.

1.2.5 stripe: A variation within one or several threads, which may or may not be adjacent, in the warp direction.

Section 2: Yarn defects in a woven fabric

2.1 bright yarn: A warp or weft yarn of higher lustre than the adjacent yarns.

NOTE — This defect is caused by irregularity in processing of the yarn, e.g. uneven distribution of delustrant, or by mixing yarns of different delustrant content, e.g. dull, semi-dull, etc.

2.2 broken filaments: In a fabric made from flat or low-twist continuous-filament yarns, a fibrous or hairy surface appearance that may be localized or general.

NOTE — This defect is caused by rupture of individual filaments, usually during winding or weaving.

2.3 cockled yarn: Small slub-like irregularities in the yarn that are readily extensible.

NOTE — This defect is often caused by the unintentional introduction of stretch into some fibres during drafting and the subsequent relaxation of these fibres to form loops or crimps in the yarn.

2.4 faulty texturing: Portions of a bulked yarn that differ from the normal yarn in respect of degree of crimp and similar distortions of the filaments.

NOTE — This defect is caused by a lack of control during texturing processes.

2.5 fine yarn; thin end; thin pick: A yarn whose thickness is unacceptably less than that of the adjacent yarns.

NOTE — This defect is caused by variation in the linear density of the yarn.

2.6 gout: A lumpy, asymmetrical fault in a spun yarn of a fabric.

NOTE — This defect is caused by the accumulation of undrafted waste fibre into the yarn during spinning.

2.7 slub: In a yarn, a thickened place having tapering ends and a diameter several times that of the adjacent normal yarn.

NOTE — This defect is often caused by the presence in the yarn of fragments of undrafted roving or slubbing that have not been cleared during winding.

2.8 soiled yarn: An individual yarn, in either warp or weft, that is discoloured by dirt, oil or other contaminants.

NOTE — This defect is caused by the contamination of the yarn prior to, or occasionally during, weaving.

2.9 split yarn: A yarn which appears in the fabric as a thin yarn.

NOTE — This defect is often caused by abrasion or excessive tension during winding or weaving which breaks a part of the yarn (e.g. a filament of a continuous-filament yarn or a ply of a two-fold yarn) that is subsequently held back during weaving.

Section 3: Defects in the weft direction

3.1 bar, weft bar: A band with clearly defined edges, which differs in appearance from the adjacent normal fabric.

NOTE — This defect is often caused by variation in weft yarn characteristics, e.g. composition, linear density, tension, twist, etc.

3.2 broken pick; dropped pick: A weft yarn which is present for only part of the fabric width.

NOTE — This defect is caused by a weft yarn breaking, running out, or being prematurely released during insertion.

3.3 chopped weft: Weft that has been partially severed.

NOTE — This defect is often caused by cutting by the reed during beat up.

3.4 coarse pick; coarse weft; thick pick: A weft yarn of substantially greater thickness than that of the adjacent weft yarns.

NOTE — This defect is caused by variation in the linear density of the weft yarn.

3.5 double bow, weft: Weft yarns in a fabric which exhibit an approximately sinusoidal waveform for more than three-quarters of the wavelength.

NOTE — This defect is caused by a lack of control in fabric manufacture or processing.

3.6 double pick: A disruption of the weave pattern similar in appearance to a thick pick but where two yarns are in the same shed.

NOTE — This defect is caused by the insertion of two weft yarns in the same shed when only one was intended.

3.7 dragged-in weft; jerked-in weft; lashed-in weft; pulled-in filling: An extra length of weft yarn that has been inserted for a part of the fabric width, usually starting from the selvedge.

NOTE — This defect is often caused after a pirn (quill) change due to a loose tail being woven in with a subsequent pick because cutters or suction devices were inactive.

3.8 kinky weft; looped yarn; weft kinks: Exposed loops of weft yarn.

NOTE — This defect is often caused by poor tension control of weft yarns during winding, unwinding or insertion.

3.9 mispick: Weft yarn which does not conform to the intended weaving pattern.

NOTE — This defect is caused by an incorrect sequence of weft insertion.

3.10 missing pick; missing weft yarns: A bar across the fabric where no weft has been inserted.

NOTE — This defect is often caused by an interruption of the weft supply, a faulty weft stop motion, or drawing through.

3.11 mixed filling; mixed weft: Two or more yarns of different characteristics appearing adjacent to one another.

NOTE — This defect is often caused by the mixing of yarn batches or by the use of different yarn types.

3.12 paired weft: Regroupment of weft yarns in pairs, apparent as weftway ribs.

NOTE — This defect is often caused by healds raised to different heights, allowing weft yarns to be beaten up alternately more and less tightly.

3.13 pick-out mark; pulling-back place: A weftways band characterized by a chafed or fuzzy appearance.

NOTE — This defect is caused by the pulling out of the original picks and subsequent reweaving.

3.14 repping: A bar in a fabric in which a prominent weftway rib is evident.

NOTE — This defect is often caused by differential relaxation of the upper and lower sheets of warp during a loom stoppage.

3.15 set mark; starting place; start-up place: A prominent band of greater or lower weft density that has a clearly defined beginning and which gradually merges away to normal fabric.

NOTE — This defect is caused by restarting a loom without sufficient care on the part of the weaver, or after standing.

3.16 shiner: A continuous-filament yarn of higher reflectance than the adjacent yarns.

NOTE — This defect is caused by a continuous-filament weft yarn having been inserted under a higher tension than that of the adjacent weft yarns.

3.17 slack filling; slack pick; slack weft: A weft yarn that appears slightly puckered in relation to the adjacent weft yarns.

NOTE — This defect is caused by a weft yarn having been inserted under a lower tension than that of the adjacent weft yarns.

3.18 sloughed-off weft: Several thicknesses of weft yarn appearing in the position intended for one weft yarn for a limited width.

NOTE — This defect is caused by one or more coils of weft yarn slipping from a loosely wound pirn and being woven into the fabric.

3.19 stitching; undershot: A weftways float on the back or face of the fabric, usually extending over several warp yarns.

NOTE — This defect is caused by the shuttle leaving the shed prematurely and travelling above or beneath the warp threads due to incorrect loom geometry, incorrect angle of shuttle launch, poor condition of shuttle, or ends clinging together.

3.20 thick place: A prominent band in which an increase in weft density, compared to that of the rest of the fabric, is apparent.

NOTE — This defect is often caused by a poor start-up of the loom, or uneven let-off or take-up.

3.21 thin place: A prominent band in which a decrease in weft density, compared to that of the rest of the fabric, is apparent.

NOTE — This defect is often caused by uneven warp let-off or fabric take-up.

3.22 tight filling; tight pick; tight weft: A weft yarn which is under greater tension, or exhibits less crimp, than the adjacent weft yarns.

NOTE — This defect is caused by a weft yarn having been inserted under a greater tension than that imposed on the other weft yarns, or relaxation of picks subsequent to insertion.

3.23 weft crackiness: Fine weftways cracks distributed randomly across the whole or part of the fabric.

NOTE — This defect is often caused by variations in warp let-off and fabric take-up when weaving an underset fabric, or irregularities of cohesion points in man-made intermingled continuous-filament yarns.

3.24 wrong weft: Weft which is distinctly different from the normal weft in a fabric.

NOTE — This defect is caused by a lack of control of incoming material.

Section 4: Defects in the warp direction

4.1 bow, warp: Excessive curvature of the warp in a fabric.

NOTE — This defect is often caused by lack of control during warping resulting in a variation in warp tension across the width during weaving.

4.2 broken end; end out; missing end: A warpways line where a warp yarn is absent for part or all of the piece.

NOTE — This defect is often caused by a warp yarn break which has not been repaired.

4.3 buttons; skin back: Balls of fibre that encircle the warp yarns and are woven into the fabric.

NOTE — This defect is often caused by the chafing of the warp yarns by the reed, heald eyes, or drop wires and is usually found in unsized or low-twisted yarns.

4.4 coarse end; thick end: A warp yarn thicker than the adjacent warp yarns.

NOTE — This defect is often caused by a wrong yarn being entered or a yarn of long-term linear-density variation.

4.5 crack: A narrow streak running parallel to the warp threads, characterized by the existence of a marked space between two adjacent threads.

NOTE — This defect is often caused by an imperfect reed, or a worn or maladjusted temple.

4.6 double bow, warp: Warp yarns in a fabric which exhibit an approximately sinusoidal waveform for more than three-quarters of the wavelength.

NOTE — This defect is often caused by lack of control during warping.

4.7 draw back; tie back; warp holding place: A warp-faced area of a fabric where the weft yarns are predominant.

NOTE — This defect is caused by entanglement behind the shafts or harness, putting tension on several adjacent warp threads.

4.8 misdraw; wrong draft; wrong draw: Warp yarns that do not conform to the required draft plan.

NOTE — This defect is caused by yarns being drawn into the heald wires in the wrong sequence.

4.9 reediness: A series of fine reed marks across the fabric.

NOTE — This defect is often caused by the use of an unsuitable comb or reed, or by incorrect drawing-in or finishing.

4.10 reed mark: A warpways crack or disturbance of the fabric structure which is not associated with missing yarns and where the weft dominates.

NOTE — This defect is often caused by a reed misdraw or by a damaged or defective reed.

4.11 slack end: A warp yarn that appears puckered.

NOTE — This defect is caused by a warp yarn having been woven under a lower tension than that of the adjacent warp yarns.

4.12 tight end: A warp yarn which exhibits less crimp in the fabric than do the adjacent normal ends, often resulting in the weft dominating the surface.

NOTE — This defect is often caused by a greater tension having been imposed on an individual warp yarn during beaming, dressing or weaving.

4.13 wrong end: A warp yarn which is distinctly different from the adjacent warp yarns in a fabric.

NOTE — This defect is caused by a lack of control of incoming material.

Section 5: Defects due to, or apparent after, dyeing, printing or finishing

5.1 **bias weft; skew**: A fabric condition in which the warp and weft yarns are straight but vary from the perpendicular to one another by a degree which is unacceptable in that fabric type.

NOTE — This defect is often caused by inadequate control of the fabric during open-width finishing.

5.2 **blanket mark**: The appearance in relief form, on the fabric, of the weave (or other surface features) of the blankets used to control the fabric during certain finishing processes.

NOTE — This defect is caused by heat, moisture, pressure, or a combination of these which, when applied to the fabric, sets the impression of the blanket into it.

5.3 **bleeding; colour bleeding**: Loss of colorant from a coloured material in contact with a liquor, leading to an obvious coloration of the liquid or of adjacent areas of the same or other materials.

NOTE — This defect is caused by poor wet fastness of the dyeing or printing.

5.4 **blinding; dull**: Terms used to describe a marked loss of lustre of fibres during wet processing.

NOTE — This defect is caused by the inclusion within the fibre of optical discontinuities, e.g. voids, or particles of dye or pigment, that scatter light, or by an alteration in the physical structure of the dye.

5.5 **blot**: An area of uniform colour appearing incorrectly in a printed design.

NOTE — This defect is often caused by colour paste falling on to the fabric, or contamination from printing rollers or a screen.

5.6 **bow, weft**: Excessive curvature of the weft in a fabric, that may or may not extend over the full width.

NOTE — This defect is caused by a lack of control in fabric manufacture or processing.

5.7 **bronzing**: A coppery lustre on a fabric surface.

NOTE — This defect is caused by excessive dyestuff present during dyeing, or by precipitation of the dyestuff.

5.8 **bruise**: An area of localized compression within a fabric.

NOTE — This defect is often caused by the squeezing or crushing of the fabric.

5.9 **centering marks; pin marks; stenter marks; tenter marks**: A series of small apertures or severed yarns running parallel to and near the fabric edges.

NOTE — This defect is caused by hooked, blunted or poorly adjusted stenter pins.

5.10 **clip mark**: A rectangular area of fabric, adjacent to the selvedge, which is characterized by bruising, lustre, surface disturbance, or a difference in colour from the adjacent normal fabric.

NOTE — This defect is caused by a maladjusted stenter clip.

5.11 **cockling; corrugation; sanforize roughness**: A crimped, rippled, wavy or pebbled place in a fabric showing distortion of the texture.

NOTE — This defect is caused during compressive shrinking by overfeeding in which the shrinkage imposed on the fabric is greater than that compatible with the construction, or by poor moisture content control.

5.12 **colour-contaminated warp yarns**: A wrong colour appearing in several (though not necessarily adjacent) warp yarns and over short yarn lengths.

NOTE — This defect may be caused by the contamination of warp yarns of, for example, one beam during warp preparation or warp dying.

5.13 **colour out**: Colours missing from an area of design in a printed fabric.

NOTE — This defect is often caused by a blocked screen or a faulty colour supply.

5.14 **colour smear**: Colour smudged out of the intended design area.

NOTE — This defect is often caused by incorrect viscosity of the printing paste, a maladjusted machine, or a poorly set or damaged doctor blade.

5.15 **crease**: A hard fold in a fabric, i.e. one that cannot be readily removed by those means normally available to a garment maker, e.g. by steam pressing.

NOTE — This defect is most often caused by distortion of the yarns during wet processing.

5.16 **crease mark**: A mark left in a fabric after a crease has been removed during fabric processing.

NOTE — This defect is the result of a permanent distortion of the yarns or damage to the fibres during creasing.

5.17 **crease streak**: A dyed-in mark of a crease, usually along the warp direction, of a lighter colour within the crease area and often with edges darker than the adjacent normal fabric.

NOTE — This defect is often caused by the fabric being pad-dyed whilst creased.

5.18 **crows' feet**: Wrinkles of varying degrees of intensity and size that give the overall effect of birds' footprints.

NOTE — This defect may be caused during wet processing or by careless folding of finished goods.

5.19 deep pinning: Conspicuous pin stenter marks appearing in the body of the fabric and so reducing the usable width of the fabric.

NOTE — This defect is often caused by incorrect feed on to a pin stenter.

5.20 doctor blade streak; doctor streak: On a fabric, a lengthways streak of excess colour or excess coating.

NOTE — This defect is caused by a damaged or incorrectly set doctor.

5.21 dye mark; dye spot; dye stain: In a piece-dyed fabric, a discrete area of different colour.

NOTE — This defect is often caused by contamination with concentrated dyestuff or dyeing assistants.

5.22 ending: A difference in colour between the bulk and one end of a piece of fabric.

NOTE — This defect is caused by the premature exhaustion of the dye bath in continuous dyeing.

5.23 halo: An area of light colour surrounding a localized thick portion of the fabric after dyeing.

NOTE — This defect is often caused by migration of dye during drying or by less dye reaching the area around the thickening (e.g. knot, slub, gout) during pad dyeing.

5.24 hang thread; long end: A short light streak, in a dyed fabric, of similar thickness to that of the warp yarns.

NOTE — This defect is caused by a partially detached warp yarn lying on the fabric surface, which inhibits the penetration of dye into the fabric beneath it.

5.25 heavy colour; machine stop: Excess colour smudged in a weftways band.

NOTE — This defect is often caused by the stopping of a printing machine, allowing more paste than normal to penetrate the fabric.

5.26 listing: A difference in colour between the selvedges and the centre of a fabric.

NOTE — This defect is often caused by uneven batching-up of the fabric or by differences in temperature from the selvedges to the centre of the fabric during dyeing and finishing.

5.27 misregister; out of register: In a printed fabric, colours not correctly positioned with respect to each other.

NOTE — This defect is often caused by printing rollers or screens not being synchronized.

5.28 mottled appearance: Variation in colour or surface effect, localized or general, which is not specifically orientated in the length or width directions.

NOTE — This defect is often caused by uneven application or penetration of dye or by surface distortion.

5.29 pilling: Small accumulations of fibre on the surface of a fabric.

NOTE — This defect is usually caused by abrasion during prolonged finishing processes.

5.30 pressure mark: An area of greater lustre, or of reduced thickness, in a fabric when compared to the adjacent normal fabric.

NOTE — This defect is often caused by irregularities of pressure during the finishing process.

5.31 rope marks: Long, irregularly shifting, longitudinal markings on dyed or finished fabrics.

NOTE — This defect is frequently caused by overloading machinery for wet processing fabric in rope form, resulting in uneven liquor penetration or the formation of creases along which abrasion or felting may occur.

5.32 scallops: The edges of a fabric exhibiting approximately sinusoidal waveforms of short wavelengths in the plane of the fabric.

NOTE — This defect often appears in a fabric which has been stretched excessively widthways during stentering.

5.33 section marks: Warp stripes which occur at regular intervals across all or part of the fabric width.

NOTE — This defect is caused by tension differences within sections during sectional warping or by differential dyeability of the yarns or variations in yarn linear density.

5.34 selvage doubling; selvedge turndown: A lengthways streak immediately adjacent to the selvedge, characterized by a difference in colour from that of the body of the fabric, by surface disturbance, or by both.

NOTE — This defect is caused by the selvedge having folded over, thus shielding the edge of the usable fabric during processing.

5.35 shading: A side-to-side change in colour across the width of the fabric.

NOTE — This defect is caused by uneven concentration of dyestuffs or by temperature variations during dyeing and finishing.

5.36 skitteriness: An undesired speckled effect in a fabric or in a yarn within a fabric.

NOTE — This defect is caused by differences in the depth of dyeing between adjacent fibres or portions of the same fibre.

5.37 streaky warp: Faint warpways colour variation of varying width and length.

NOTE — This defect is often caused by varying dye uptakes in the warp yarns due to uneven desizing or blending, or by irregularities in twist or linear density.

5.38 tailing: A continuous change in colour along the length of a piece.

NOTE — This defect is often caused by a gradual change in dye-bath concentration or temperature.

5.39 undyed crease: In a printed fabric, a well defined lengthways streak from which the colour is missing.

NOTE — This defect is caused by passing a creased fabric through the printing machine.

5.40 warp stripe: The presence, in a piece-dyed fabric, of one or more warp yarns of the wrong colour.

NOTE — This defect is caused by isolated yarns of different characteristics having been introduced during winding or warping and subsequently reacting differently during dyeing and finishing.

5.41 water spot: An unwanted pale area in a piece-dyed fabric.

NOTE — This defect is caused by contamination with water prior to tinting or dyeing on a pad mangle, which results in a reduction of uptake of dye liquor.

Section 6: Defects of, or associated with, the selvedges

6.1 baggy selvedge; loose selvedge; slack selvedge: A selvedge that is rippled and longer than the adjacent fabric.

NOTE — This defect is often caused by incorrect balance of fabric structure between the selvedge and the body of the fabric, selvedge warp yarns being woven at too low a tension, or careless handling of the fabric.

6.2 beaded selvedge; corded selvedge: A selvedge in which the warp yarns have pulled together to form a cord.

NOTE — This defect is often caused by excessive warp tensions or poor control of the selvedge at the fell of the fabric.

6.3 burst selvedge; ripped selvedge; torn selvedge: Three or more adjacent selvedge yarns, including the outermost, or catch, yarn, which are severed.

NOTE — This defect is often caused by poor construction of the selvedge or by undue strains imposed during weaving or finishing.

6.4 cracked selvedge: A selvedge in which two or more adjacent warp yarns, not including the catch thread, are ruptured.

NOTE — This defect is often caused by mechanical damage or unbalanced warp tensions.

6.5 loopy edge; loopy selvedge: A selvedge beyond which loops of weft yarns protrude.

NOTE — This defect is often caused by the yarn tension in the shuttle being too low.

6.6 tight selvedge: A selvedge that is shorter than the adjacent fabric.

NOTE — This defect is often caused by incorrect balance of fabric structure between the selvedge and the body of the fabric, selvedge warp yarns having been woven at too high a tension, or careless handling of the fabric.

Section 7: General defects

7.1 abrasion mark; chafe mark: An area of localized wear characterized by excessive surface hairiness or denuded fibre.

NOTE — This defect is often caused by chafing or oblique impact with a hard or rough surface.

7.2 bad cover; poor cover: Warp yarns generally showing between the weft yarns unintentionally, or vice versa.

NOTE — This defect often occurs in an undersett fabric, or through poor finishing.

7.3 bad odour: A disagreeable smell that is not usually associated with the fabric.

NOTE — This defect is often caused by the breakdown of finishing resins, fermented starch, mildew, or the presence of other contaminants.

7.4 broken colour pattern: Coloured weft yarns appearing in the fabric in the wrong sequence.

NOTE — This defect is often caused by failure to reset the pattern control after a loom stoppage.

7.5 cannage; tear drop; teariness: Short elliptical deviations of one or more adjoining picks, leading to local differences in light reflection in a fabric having a plain or other simple weave and a continuous-filament warp.

NOTE — This defect is often caused by the warp being too heavily sized, or the warp tension being too low during weaving, or by variations in the configuration of the weft yarns.

7.6 coloured flecks; coloured fly: A small quantity of coloured fibre unintentionally incorporated into the structure of a fabric of a different colour.

NOTE — This defect is often caused by small amounts of coloured waste fibre being spun into a yarn of another stock, or by different fibres or colours running or being woven in close proximity without adequate precaution against contamination.

7.7 disturbed place: An area where the weave has been disarranged, but where the yarns are undamaged.

7.8 emboss mark; impression mark; seam mark: A small area of the fabric standing out in relief.

NOTE — This defect is often caused by the relief print-off of defects, such as slubs, or of seams used to join lengths of fabric, under excessive rolling tension, or contraction on the roll during wet processing.

7.9 finger mark: An irregular spot showing variation in picks per unit length for a limited width.

NOTE — This defect is often caused by mechanical interference on a small scale.

7.10 float: In a fabric, a length of yarn that is unbound over two or more successive ends or picks.

NOTE — This defect may be caused by a slack warp end or a faulty pattern card.

7.11 fogmarking: Localized soiling of the fabric usually confined to edges and folds, though sometimes apparent as bars.

NOTE — This defect is often caused by deposition of atmospheric dirt during waiting periods in processing or when the fabric is stored in plated form, and is often aggravated by static-charge attraction.

7.12 foreign body: An inclusion of non-textile matter.

NOTE — This defect is often caused by insufficient attention to the cleanliness of looms and of the weaving shed.

7.13 foreign fibres: Fibres of a different type and/or colour from the other fibres in the fabric.

NOTE — This defect is caused by the contamination of the fabric by extraneous fibre which is either included in the yarn or woven into the fabric.

7.14 hang pick: Short loops of weft yarn at the surface of a fabric for several picks or a small triangular aperture in a fabric but where no yarns are severed.

NOTE — This defect is caused by weft yarns catching on a prominent warp yarn knot for a split second during beating up or until the knot has reached the fell of the cloth.

7.15 hole: A breakdown in the fabric where two or more adjacent yarns are severed.

NOTE — This defect can be due to very many causes, amongst which are: careless handling of the fabric, defective machine elements (such as take-up rollers or temples), chemical damage, insect damage or damage during finishing such as lack of control during singeing, shearing, etc.

7.16 loopy pile: Loops in a terry fabric that are longer than adjacent normal loops.

NOTE — This defect is commonly caused by interference with the formation of individual pile loops, as the result of incorrect shedding, drawing-in, etc.

7.17 mingled pile: Terry loops of contrasting colour appearing on the wrong side of the fabric.

NOTE — This defect is commonly caused by interference with the formation of individual pile loops, as the result of incorrect shedding, drawing-in, etc.

7.18 neppy fabric: An excessive number of small tangles or knots of fibre appearing on the fabric surface.

NOTE — This defect is often caused by poor carding or combing of fibre or by contamination during preparation for spinning.

7.19 over-raised: Excessive surface nap that may or may not be accompanied by damage to the ground structure.

NOTE — This defect is caused by the incorrect setting of the raising machine or irregular feed of the fabric.

7.20 shuttle trap mark: A disturbance of the weave or a localized pucker of the fabric that extends over an area corresponding to the dimensions of a shuttle.

NOTE — This defect is caused by an incomplete cycle of the picking motion, causing a trapping of the shuttle between the reed and the fell of the cloth.

7.21 smash: A relatively large hole in a fabric characterized by many broken warp ends and floating picks, or a prominent mark left behind after repairing such a hole.

NOTE — This defect is caused by several heald wires breaking or by a defective picking motion.

7.22 snag: A yarn, or fibres or filaments from a yarn, standing out from the fabric as a long loop.

NOTE — This defect is caused by a yarn, or fibres or filaments from a yarn, catching on a sharp projection and being drawn out from the structure.

7.23 snarl: A short unbroken length of warp or weft yarn which is doubled-up in the fabric.

NOTE — This defect is often caused by a yarn under insufficient tension twisting about itself, either prior to or during weaving, and by twist liveliness.

7.24 stain: A discrete area of discoloration of a fabric.

NOTE — This defect is caused by contamination with extraneous substances such as dirt, oil or rust.

7.25 stitched place: An area where the interlacing of the warp and weft threads does not conform to the planned weave.

NOTE — This defect is frequently caused by one or more ends being lifted out of sequence by an adjacent end or heddle.

7.26 tear: An opening in the structure of a fabric in which several warp or weft yarns, or both, are severed.

7.27 temple cutting: Fracture or damage of the warp yarns, weft yarns, or both, adjacent to the edge of the fabric.

NOTE — This defect is often caused by hooked, flattened, or otherwise damaged temple pins during weaving.

7.28 temple mark: A disturbance of the weave adjacent and parallel to the selvedge.

NOTE — This defect is often caused by a poorly adjusted temple.

7.29 terry off: A band in a terry section that has no terry loops.

NOTE — This defect is caused by incorrect let-off motion.

7.30 terry on plain: Terry loops appearing within a plain area of a terry fabric.

NOTE — This defect is caused by incorrect let-off motion.

7.31 trammage: A puckered area in a crêpe fabric.

NOTE — This defect is caused by failure to insert wefts of alternate S and Z twists when so required by the structure.

7.32 under-raised: Insufficient coverage of the ground structure of a raised fabric.

NOTE — This defect is caused by the incorrect setting of the raising machine or an insufficient number of passes of the fabric through the raising machine.

7.33 uneven appearance: A fabric that is unacceptable in terms of overall character.

NOTE — This defect may be due to numerous small blemishes, e.g. uneven yarn, small slubs, that individually would not constitute a fault.

7.34 uneven raising: Irregularities in the appearance of a raised fabric where areas of under-raising and/or over-raising are present.

NOTE — This defect may be caused by variations in the fabric structure or in processing prior to raising, or to lack of control of the raising machine.

7.35 unwanted twill: Twill lines introduced unintentionally into a fabric.

7.36 water damage: A stain that has a sharply defined straight or wavy edge and that fades away rapidly to normal colour.

NOTE — This defect is caused by deposition of dye, soil or finishing compounds carried by water wicking through the fabric, and represents the furthest point of this migration.

7.37 water mark: Irregular light and dark bands giving a rippled effect similar to moiré.

NOTE — This defect is caused by the fabric having been subjected to excessive heat and/or pressure and occurs more often in fabrics having a ribbed or corded weave.

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